

Work Order ID 50130 -2

July 8, 2009 12:48:45 PM



split

Page 1

Item ID: D2807-041

Accept



Setup Start



Revision ID: E

Stop



Item Name: Door prop

Start Date: 7/08/09

Start Qty: 40.00



Cust Item ID:

Required Date: 7/10/09

Req'd Qty: 40.00

87



Customer:

Reference:

Approvals:

Process Plan: C209/07/08

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2807

Rev E

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 10032 Order as per Dwg D2807 Possible
supplier: Lift Support Technologies, Saskatoon, Canada P/N 6/15-164/50-115N

11

Material release note is required

C2 09/07/08 40

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

P 9/1/9 36

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

counts
= 78 09/07/10 (136)

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

1-install D3671-1 as per dwg D2807

0.00

0.00

CP 09/07/15 (7)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

⇒ Serial is (47) f

150



Packaging

Packaging

Identify as per dwg & Stock Location: 49

Memo

0.00

0.00

9/7/15

(7x) SD

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Item ID: D2807-041

Accept



Setup Start



Revision ID: E

Stop



Item Name: Door prop

Start Date: 7/08/09

Start Qty: 40.00



Cust Item ID:

Required Date: 7/10/09

Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/16 HJ

MF 09-07-16

Picklist Print

Page 1

July 8, 2009 12:48:45 PM

Work Order ID: 50130

Parent Item: D2807-041RevE

Parent Item Name: Door prop

Comments:

Start Date: 7/08/09

Required Date: 7/10/09

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3671-1RevA

Manufactured

No

110

Each

29.0000

40.0000



Placard

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

44911

29

29

6/15-164/50-115N

Purchased

No

130

Each

0.0000

40.0000



Gas Spring

109/7/16

9/7/10 36x

350174 6/9/07/15

50330 9/7/10 36x

SPECIFICATION CONTROL DRAWING



(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH $\phi 0.375$ TOOL AT
2000psi (REF), TYP TWO
SIDES PER LUG

0.24 TO CRIMP
(TYP)

D2807-5
OR
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3
BOTH ENDS

ARROW POINTS OUTBOARD
ARROW POINTS OUTBOARD

4.88
COMPRESSED

6.46
EXTENDED

D2807-041 GAS SPRING

RELEASED
RCA-2 11/80

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

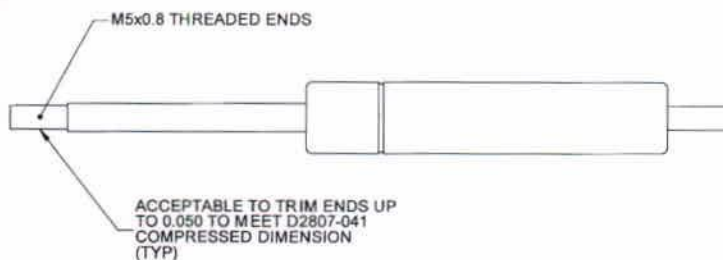
QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)
(WEIGHT: 0.176 LBS)

E	ADD D2807-5 GAS SPRING; D2807-1/-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV	DESCRIPTION	BY	DATE
DESIGN	44	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	44		
CHECKED	44	DRAWING NO.	REV. E
MFG. APPR.	44	D2807	SHEET 1 OF 3
APPROVED	44	TITLE	SCALE
DE APPR.	44	GAS SPRING	NTS
DATE	07.12.28	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

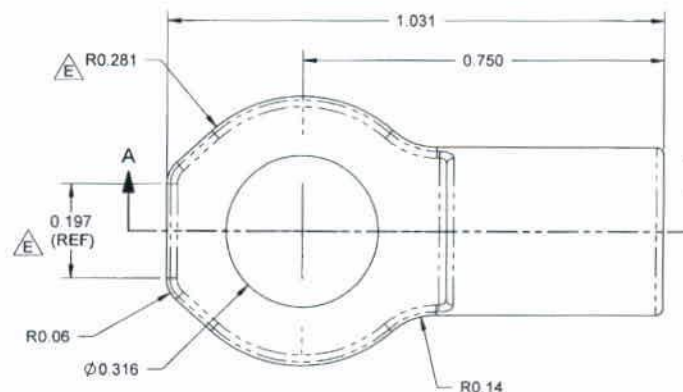
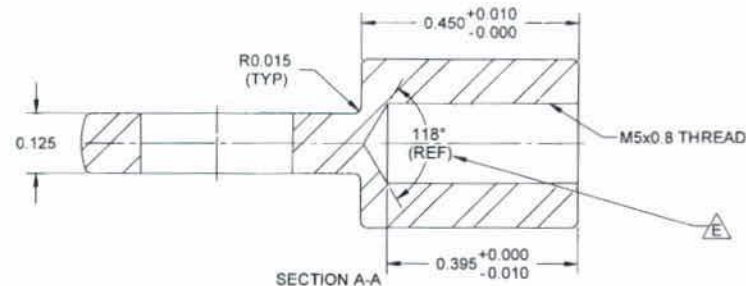
W10:50130
C209108108



D2807-1 GAS SPRING
SCALE 1:1

D2807-1 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS



D2807-3 LUG

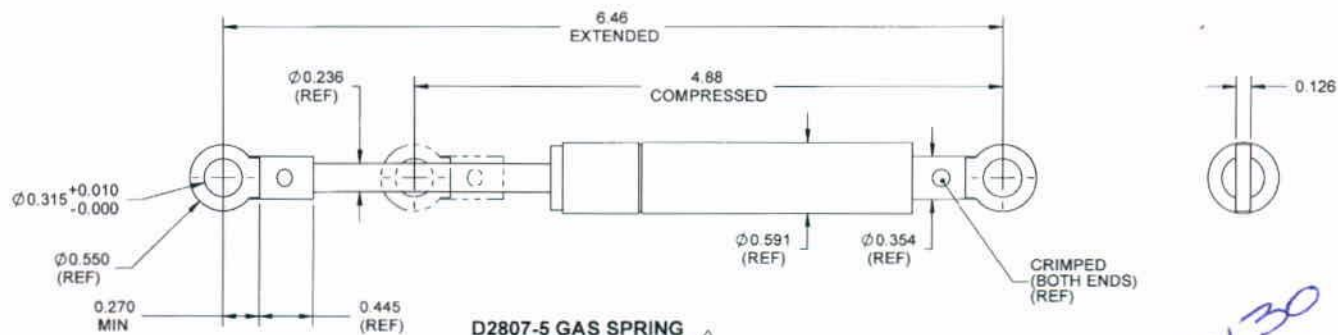
D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

DESIGN	H	DART AEROSPACE LTD	
DRAWN	H	HAWKESBURY, ONTARIO, CANADA	
CHECKED	H	DRAWING NO.	REV. E
MFG. APPR.	H	D2807	SHEET 2 OF 3
APPROVED	H	TITLE	SCALE
DE APPR.	H	GAS SPRING	4:1
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50130

RELEASED



D2807-5 GAS SPRING

D2807-5 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA
(P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.168 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS.
ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HE	DRAWING NO.	REV. E
MFG APPR	HE	D2807	SHEET 3 OF 3
APPROVED	HE	TITLE	SCALE
DE APPR.	HE	GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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303 – 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403
E-mail: lstech@lstechnologies.ca www.liftsupporttechnologies.com

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

36 Units: D2807 Gas Spring

Country of Manufacture: Canada
Date of Manufacture : 2009
This product is ROHS compliant.

We certify no mercury was used in the manufacture of this order.

Purchase Order # 10032
Invoice # 5202

0760710

L S Technologies Inc Canada

Nolan Fehr
Manager

LS Technologies Canada Inc.

303 - 103 Street
Saskatoon, SK Canada
S7N 1Y9

Packing Slip

P.O. No.	Date	Packing Slip #
10032	7/8/2009	5202

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Rep	Ship Date	Ship Via
Nolan	7/8/2009	Purolator - AIR

Qty	Description
36	D2807 - Stainless Gas Spring Shipping via PUROLATOR - Tracking # 329110098129 Total GST Business Number: 875007718